

Work Order ID 69140



Page 1

Tuesday, May 03, 2011 10:53:42 AM

Item ID:	D3913-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Long Basket Base Assembly, 350					
Start Date:	5/3/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	5/9/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Ship May 18th

Approvals:	Process Plan:		Date:	10-5-3	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3913	A								
D4020	A								

100	Weld per dwg A/R S.S. rod Batch: 4115778	0.00							
	Large Fab								
Large Fab	Memo	0.00							

1- assemble ribs , weld as per dwg D3913 using DT9610A
 inspect before welding mesh
 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913
 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends
 3- weld hinge (3) and Mounting brackets as per dwg D3913
 take lid to locate hinge and bracket

11.05.12 (1x)

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	QC								
Quality Control	Memo	0.00							

11.05.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 69140

Tuesday, May 03, 2011 10:53:43 AM



Page 2

Item ID: D3913-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Base Assembly, 350

Start Date: 5/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

8/6/5/13



125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

IX / M-11/08/13

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
-----	-----------------------------------------------	------	--	--	--	--	--	--	--



Powdercoat

Powder Coating

Memo

0.00

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

M116964

IX ~~Q~~ M-14/05/13

140	QC3- Inspect Part Finish	0.00							
-----	--------------------------	------	--	--	--	--	--	--	--



QC

Quality Control

Memo

0.00

SAD

11-05-13

①

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

Pick Kit

EP 5/4/05/16 @

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5/11/05/16

(4)

170

Identify as per dwg & Stock Location

0.00



Packaging

Memo

W/069135 @

Packaging

EP 5/4/05/16 @

W/O:		WORK ORDER CHANGES					
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Reference:

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Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/16 [Signature]

R11-0514
(1)

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, May 03, 2011 10:53:49 AM

Page 1

Work Order ID: 69140

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/3/2011





Required Date: 5/9/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581  Mounting Bracket		Manufactured	No			100	Each	12.0000	2	2		11.05.12	
						<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>				
						WA005		12		368964 → (2)			
						66806		12					
D3913-1  Rib		Manufactured	No			100	Each	3.0000	1	1		11.05.12	
						<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>				
						WA		1					
						68184		1					
						WA006		2					
						68418		2		(2)			
D3913-15  Wide Handle Plate		Manufactured	No			100	Each	2.0000	1	1		11.05.12	
						<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>				
						WA005		2		(1)			
						68176		2					
D3913-3  Rib		Manufactured	No			100	Each	2.0000	1	1		11.05.12	
						<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>				
						WA006		2		(1)			
						68185		2					

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Page 2

Work Order ID: 69140

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/3/2011

Required Date: 5/9/2011

Start Qty: 1.00

Required Qty: 1.00

D3913-7

 Rib

Manufactured No

100 Each

10.0000

2

2



Handwritten signature 11.05.12

Location

Loc Qty

Loc Code

WA006

10

65278

1

66435

1

67982

2

68417

6

②

D3913-9

 Hinge Rib

Manufactured No

100 Each

5.0000

1

1



Handwritten signature 11.05.12

Location

Loc Qty

Loc Code

WA006

5

68186

2

68590

3

①

D3916-041

 Rib Assembly

Manufactured No

100 Each

0.0000

2

2



B68538 → ② *Handwritten signature* 11.05.12

D3916-5

 Light Rib

Manufactured No

100 Each

7.0000

3

3



Handwritten signature 11.05.12

Location

Loc Qty

Loc Code

WA006

7

68155

7

③

Tuesday, May 03, 2011 10:53:49 AM

Shop Packet Print

Page 2

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Page 3

Work Order ID: 69140

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/3/2011

Required Date: 5/9/2011

Start Qty: 1.00

Required Qty: 1.00

D4016-1 Manufactured No
Hinge Half, Base

Location

WA
66418
67473
68426

100 Each 31.0000

Loc Qty

31
0
13
18

Loc Code



3 3
11.05.12

D4017-7 Manufactured No
Rib

Location

WA
68415
69009

100 Each 6.0000

Loc Qty

6
3
3

Loc Code



1 1
11.05.12

D4017-9 Manufactured No
Rib

Location

WA
69011
WA006
68416

100 Each 12.0000

Loc Qty

6
6
6
6

Loc Code



2 2
11.05.12

D4020-11 Manufactured No
End Mesh, Basket

Location

WA
67458

100 Each 4.0000

Loc Qty

4
4

Loc Code



2 2
11.05.12

Tuesday, May 03, 2011 10:53:50 AM

Shop Packet Print

Page 3

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Page 4

Work Order ID: 69140

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/3/2011

Required Date: 5/9/2011

Start Qty: 1.00

Required Qty: 1.00

D4021-1 Manufactured No

100 Each

13.0000

3

3



Handle Plate



11.05.12

Location

Loc Qty

Loc Code

WA

13

67474

3

68424

10

D4034-041 Manufactured No

100 Each

1.0000

1

1



Aft Upper Rib Assembly



368413 11.05.12

Location

Loc Qty

Loc Code

WA006

1

66884

1

D4034-043 Manufactured No

100 Each

0.0000

1

1



Fwd Upper Rib Assembly



369155 11.05.12

M304EX0.75-16F Purchased No

100 sf

583.3016

33

33



Expanded Metal Flat SS



11.05.12

Location

Loc Qty

Loc Code

WA

583.3016

115012

114

117197

182.3016

117455

287

AN3-10A Purchased No

150 Each

89.0000

6

6



Bolt



33.0 5/5/16

Location

Loc Qty

Loc Code

ST351

89

117313

89

6

Tuesday, May 03, 2011 10:53:50 AM

Shop Packet Print

Page 4

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Work Order ID: 69140

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/3/2011

Required Date: 5/9/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

150

Each

2,079.000

6



Nut

Location

Loc Qty

Loc Code

ST300

2079

116391

11

116540

502

116549

766

117441

800

NAS1149F0332P

Purchased

No

150

Each

124.0000

12



WASHER

Location

Loc Qty

Loc Code

ST275

124

17317

124

6
5/11/05/16

6

12
5/11/05/16

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

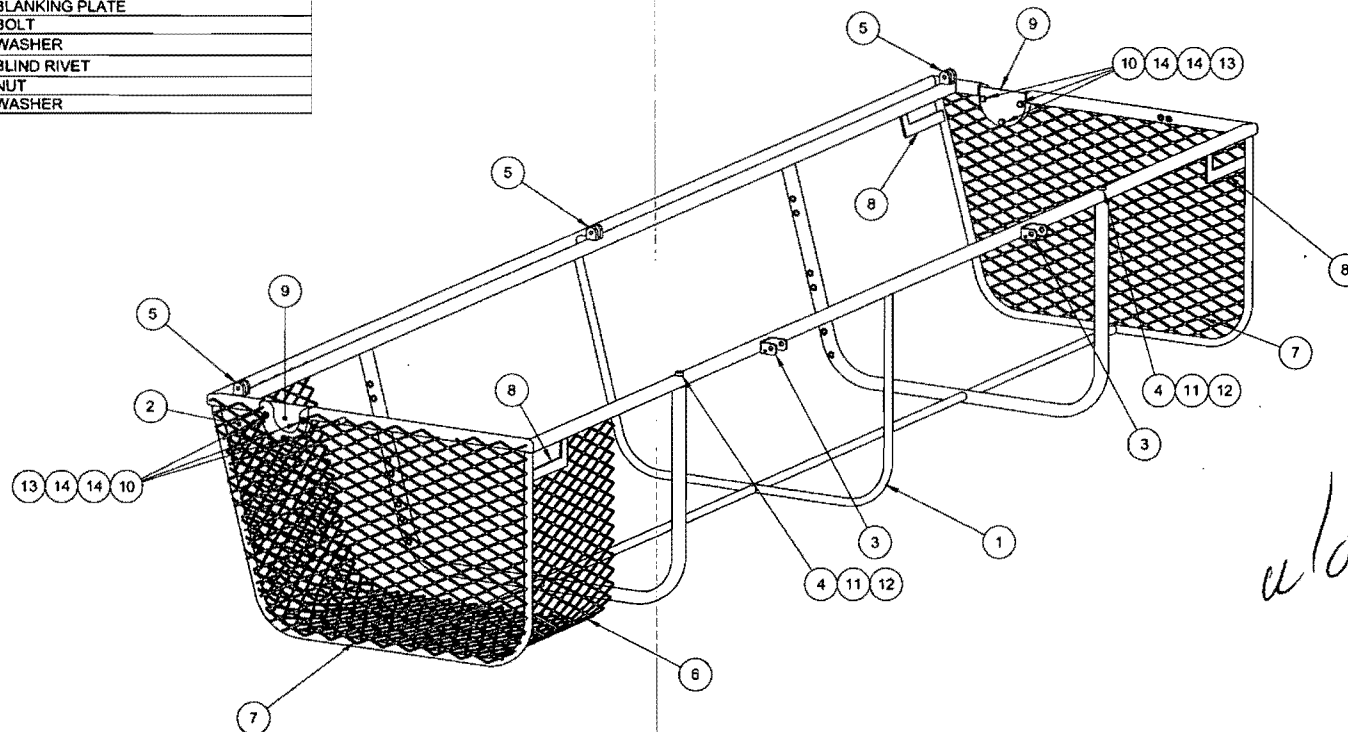
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ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

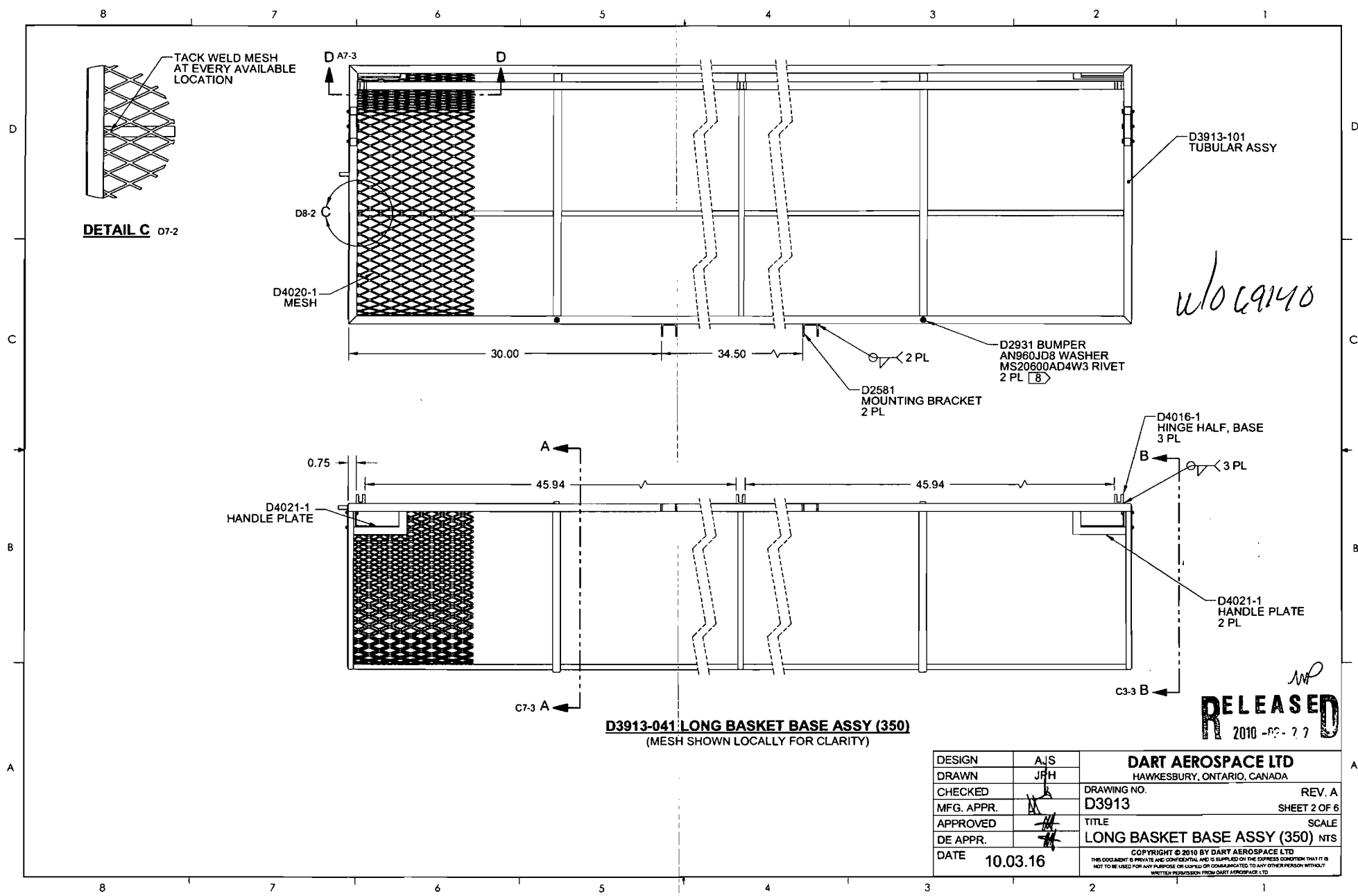
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D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JRH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3913	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 6	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LONG BASKET BASE ASSY (350) NTS	
DATE	10.03.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

RELEASED
2010-PC-77

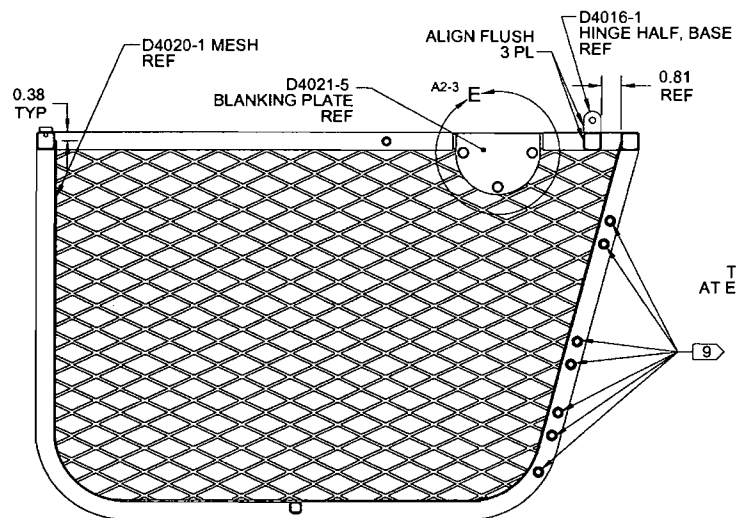
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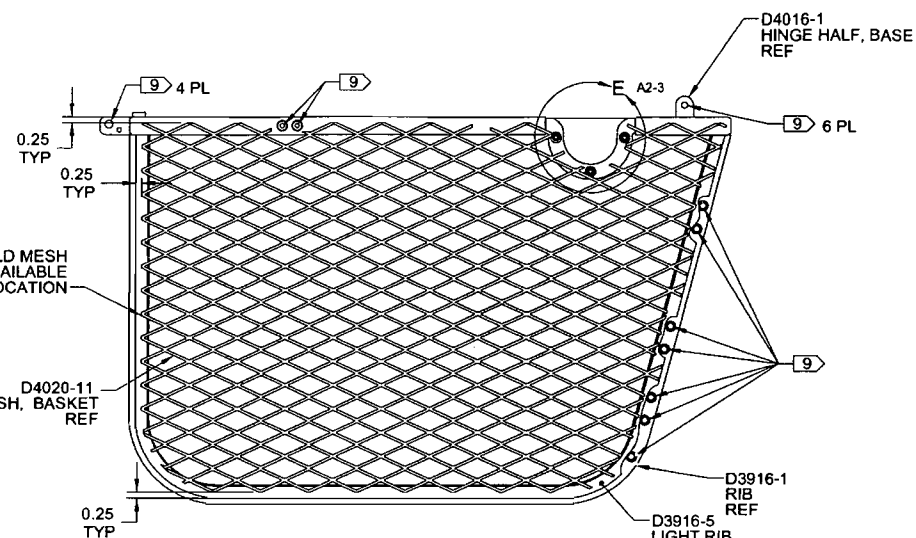
NOTE: Date & initial all entries



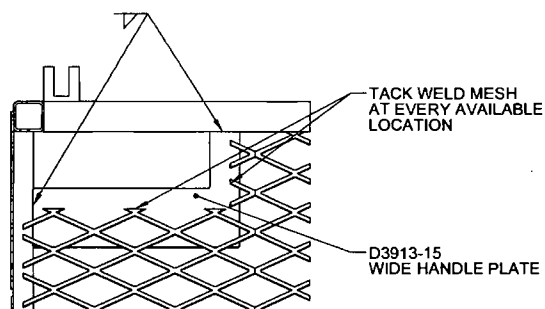
SECTION A-A A5-2

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

D4020-11
END MESH, BASKET
REF



VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES





D4021-5
BLANKING PLATE

AN3-10A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
3 PL

TRIM MESH LOCALLY
Ø0.50 - Ø0.60
TO CLEAR FASTENERS

DETAIL E D2-3
D6-3

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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u/b 69140

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

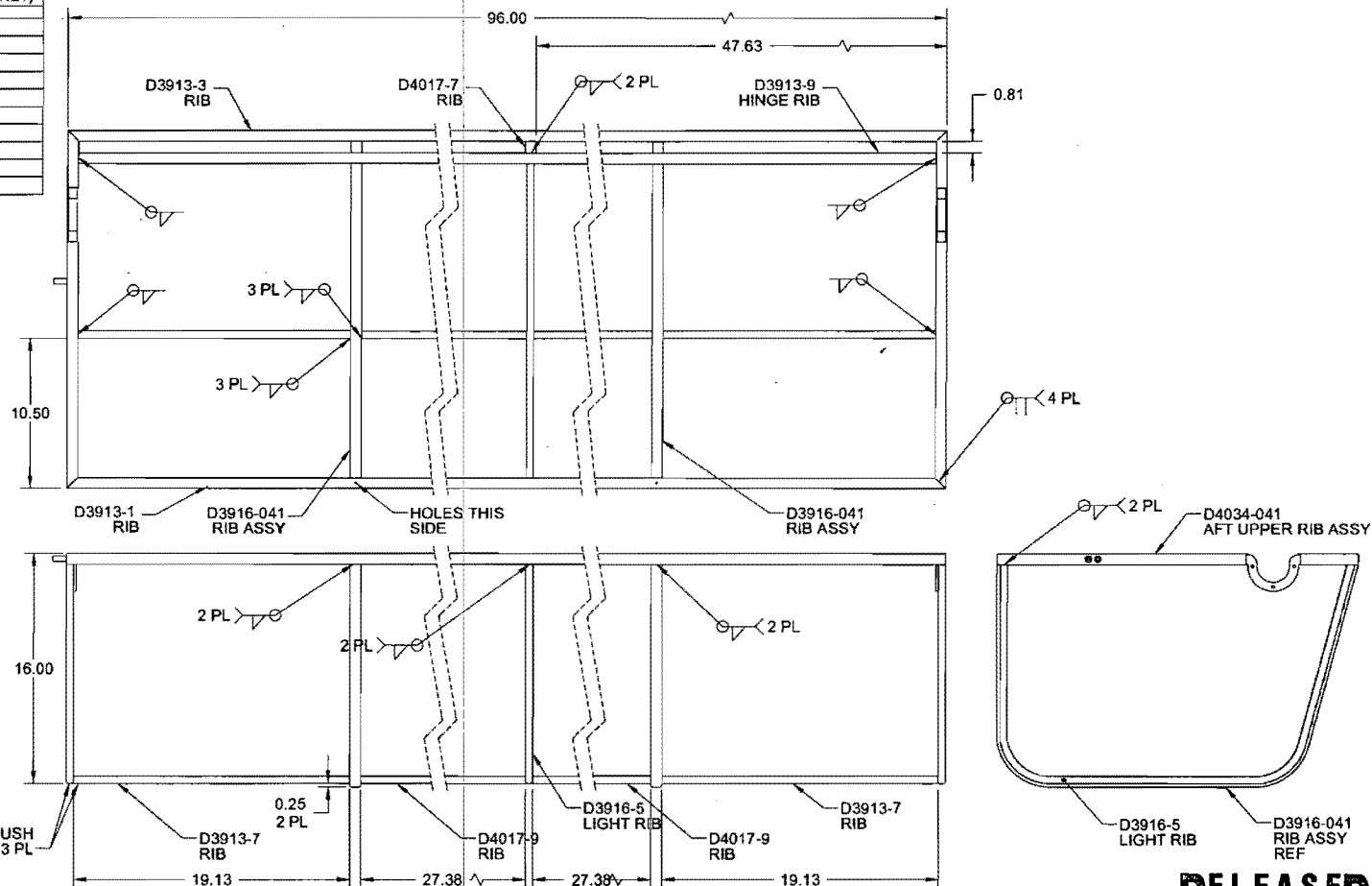
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JRH		
CHECKED		DRAWING NO. D3913	REV. A
MFG. APPR.		SHEET 4 OF 8	
APPROVED		TITLE LONG BASKET BASE ASSY (350)	SCALE NTS
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DATE	10.03.16		

RELEASED
2010-03-22

WLB 69140

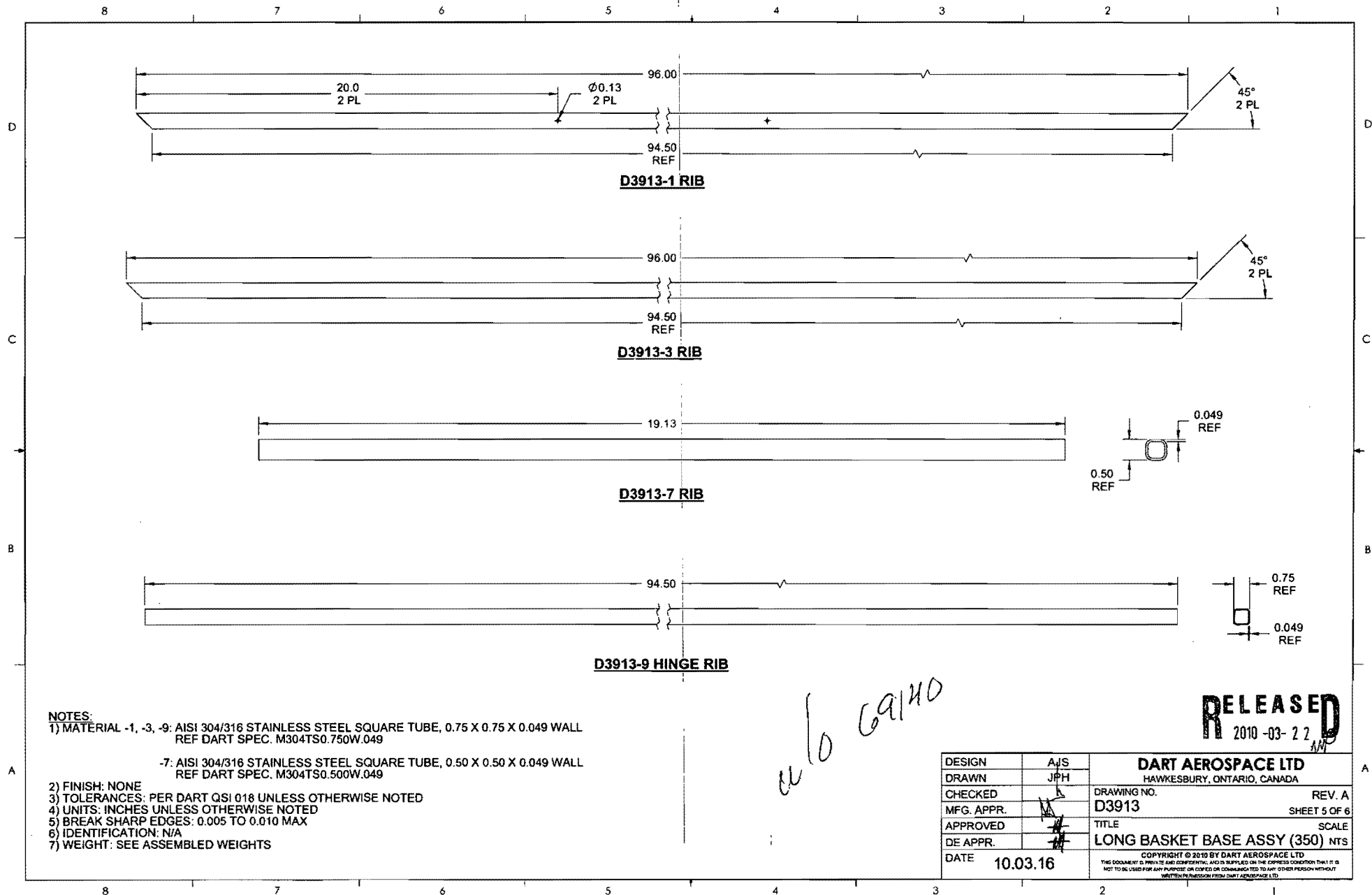
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



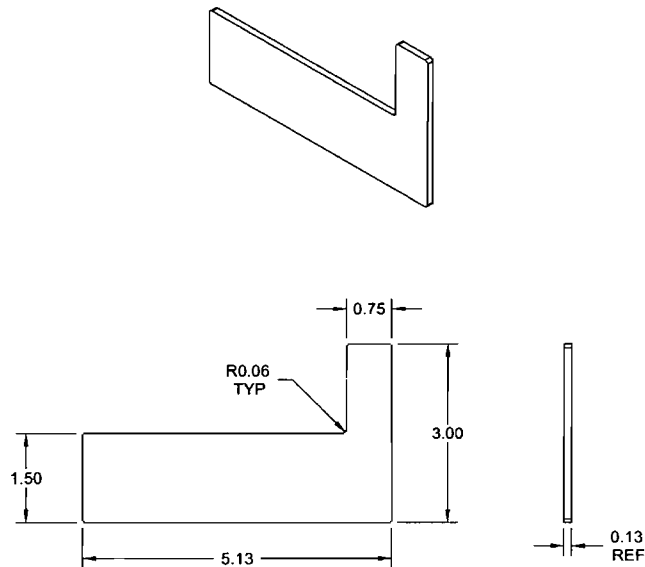
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3913-15 WIDE HANDLE PLATE

w/o 69140

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

RELEASED
2010-03-22
IND

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3913	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 6 OF 6	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LONG BASKET BASE ASSY (350) NTS	
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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